

Work Order ID 63854

Page 1

Tuesday, November 16, 2010 2:43:32 PM

Item ID: D4021-9

Accept



Setup Start



Revision ID:

Item Name: Bushing

Stop



Start Date: 11/16/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 11/23/2010 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10/11/16

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D4021	B

100



Hardinge

Hardinge CNC Lathe Small

Memo

0.00

TURN AS PER FOLIO FA 868 AND DWG D4021

DWG REV:

FOLIO REV:

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Printed: 10/11/2010 08:48 AM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

A.A 10/11/13

16

Ø

130



Packaging

Packaging

Identify as per dwg & Stock Location: P050

0.00

C2 10/11/2013

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/11/2013

MF
10-11-2013

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, November 16, 2010 2:43:36 PM

Page 1

Work Order ID: 63854



Parent Item: D4021-9



Part Item Name: Bushing

Start Date: 11/16/2010

Required Date: 11/23/2010

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A NEW ISSUE 09-11-23 JLM VERIFIED BY:DD IPP
Rev:B as per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as
per dwg revB DD 10.04.20 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R.500 		Purchased		No		100	f	48.0100	0.083	1.397895 		-31 10/11/23	

304 SS roundbar .500

Location	Loc Qty	Loc Code
MAT	44.5	
→ 115334	44.5	
MAT029	3.51	
113006	3.51	

1.2 ft *

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	23534
Description: Bushing	Part Number:	D4021-9
Inspection Dwg: D4021 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:		Audited by:		Preliminary Approval:	
Date:	10/11/23	Date:	10/11/23	Date:	

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	JK MA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

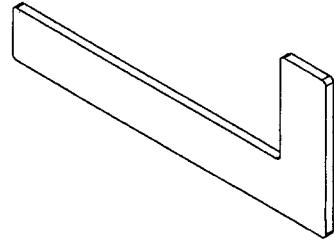
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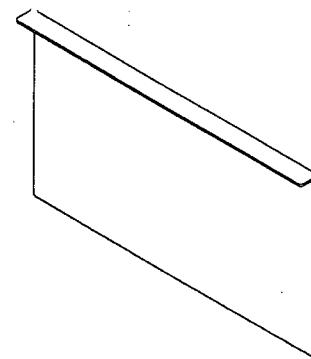
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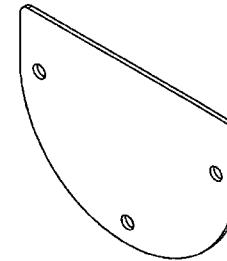
WLS 43° 51'



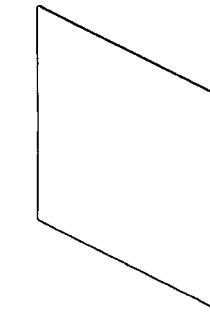
D4021-1 HANDLE PLATE



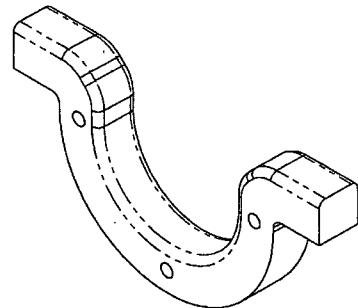
D4021-3 DATA PLATE



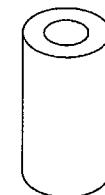
D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE



D4021-7 HOOP



D4021-9 BUSHING

RELEASED
2010-04-14
MP

B	POWDER COAT SPEC ADDED TO NOTE 2 (A8-2)		JPH	10.04.06
A	NEW ISSUE		JPH	10.01.28
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD		
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA		
CHECKED	JK	DRAWING NO. D4021		
MFG. APPR.	JK	REV. B		
APPROVED	JK	SHEET 1 OF 3		
DE APPR.	JK	TITLE	SCALE	
DATE	10.04.06	MISC PARTS - 350 BASKET	NTS	

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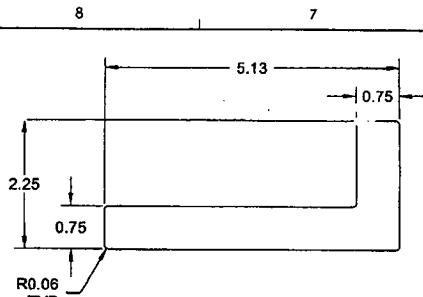
W/O:		WORK ORDER CHANGES							
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

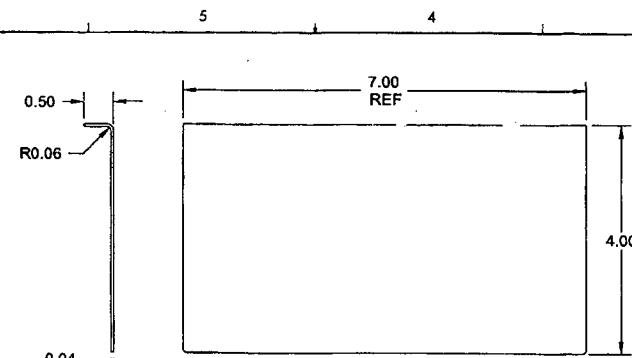
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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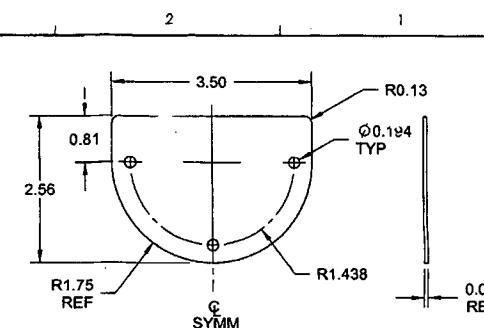
NOTE: Date & initial all entries



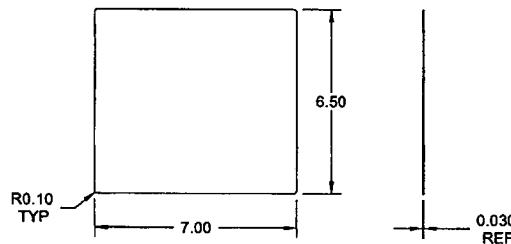
D4021-1 HANDLE PLATE



D4021-3 DATA PLATE
MAKE FROM D4021-3F



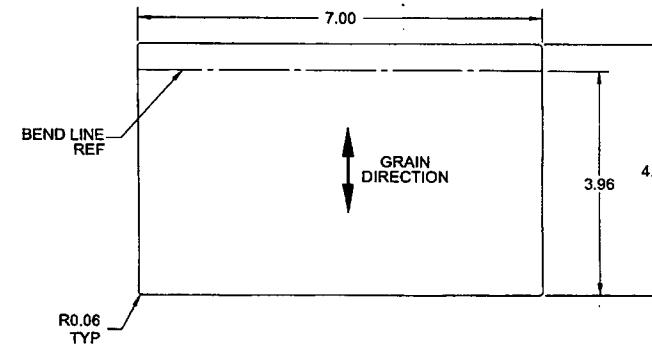
D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE

NOTES:

- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
 - 3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
 - 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OH, ASTM A240 OR ASME SA240
REF DART SPEC M303S16GA OR M304S16GA
 - 11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S22GA
- (B) 2) FINISH : -1/-3/-11: NONE
-5: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT -1: 0.18 lbs -3: 0.35 lbs
-5: 0.14 lbs -11: 0.39 lbs



D4021-3F DATA PLATE
FLAT PATTERN

RELEASED
2010-04-14
NM

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. B
APPROVED		D4021
DE APPR.		SHEET 2 OF 3
DATE	10.04.06	TITLE
		MISC PARTS - 350 BASKET
		SCALE
		NTS
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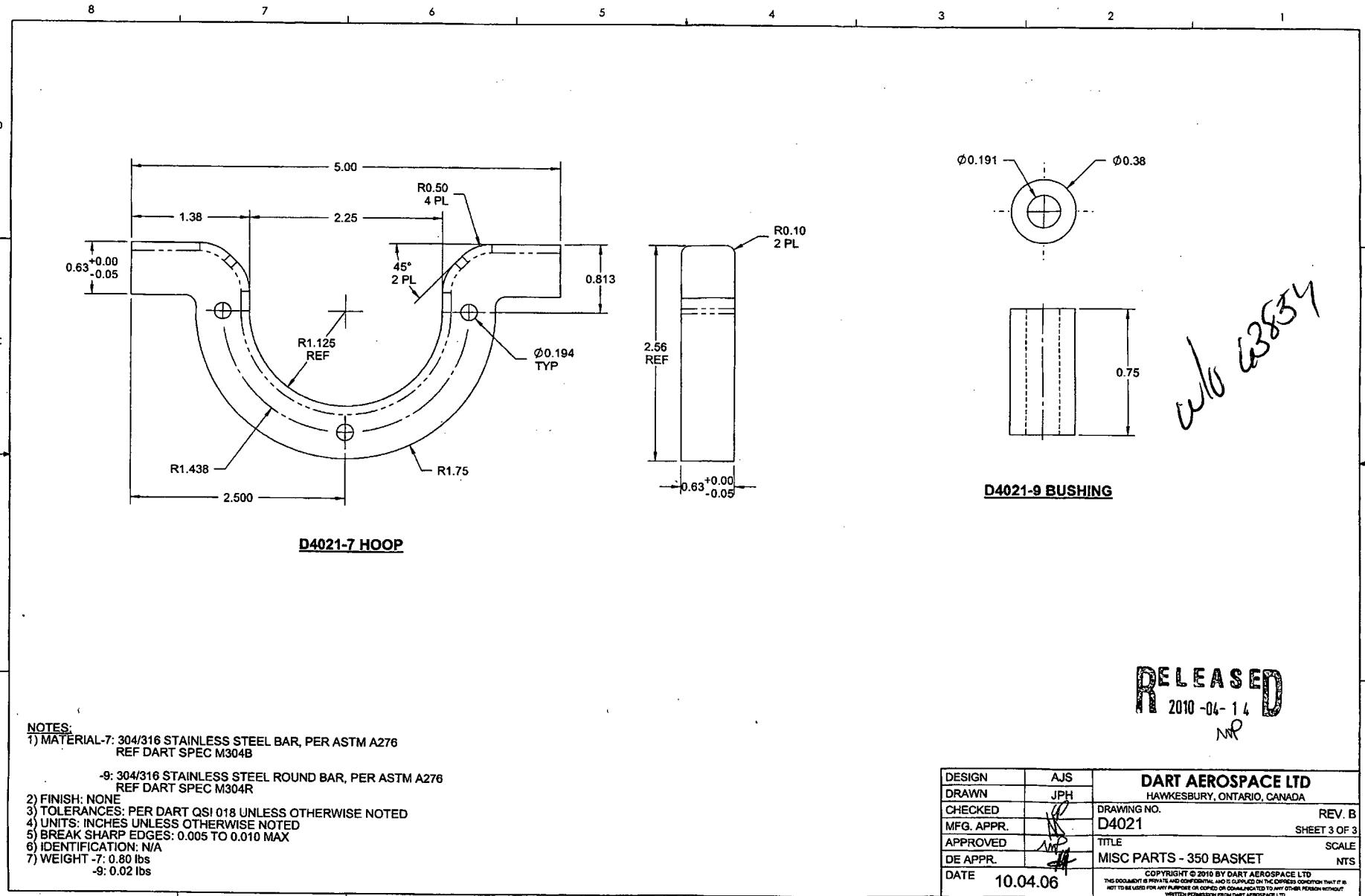
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DESIGN DRAWN	AJS JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<input checked="" type="checkbox"/>	DRAWING NO. REV. B D4021 SHEET 3 OF 3
MFG. APPR.	<input checked="" type="checkbox"/>	TITLE
APPROVED	<input checked="" type="checkbox"/>	SCALE NTS
DE APPR.	<input checked="" type="checkbox"/>	MISC PARTS - 350 BASKET
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS CUPLED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

RELEASED
2010-04-14
MR

W/O:		WORK ORDER CHANGES					
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